

Work Order ID 140325 - 2

Monday, December 21, 2015 11:53:59 AM

140325

Page 1

Item ID: D5274-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Extrusion

Start Date: 12/21/2015 Start Qty: 12.00

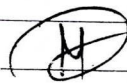
Required Date: 12/21/2015 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: 

Date: 15-12-23

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5274	A								

110

0.01

110

Small Fab
Small Fab
Large Qab.

Memo

0.00

1- CUT EXTRUSION AS PER DWG
(Make sure ends are cut square)

2- DRILL HOLES USING DT10169 AND DEBURR. (Drill one hole at the time
and put a drill bite in every holes before drilling the next)

3- C'SINK HOLES AS PER DWG

12 JAN 21 2016

DAS
24
9-80

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

12

JAN 22 2016

DAS
38
9-80

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Page 2

Item ID: D5274-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step Extrusion

Stop ***NS2***

Start Date: 12/21/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/21/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Outsource process-Anodize per QSI017 4.1.10.1	1.20							
130									
Outsource4	Memo	0.00				DAS 13		JAN 22 2016	12
Outsource process - Anodize	ISSUE P/O TO ATG: <u>31078</u>								
	ANODIZE BLACK AS PER DWG AND MIL SPEC								
	C OF C IS REQUIRED								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

5x Sp/16-028(5)DAS
38
9-28

MAR 15 2016

Work Order ID 140325

Monday, December 21, 2015 11:53:59 AM

140325

Page 3

Item ID: D5274-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Extrusion

Start Date: 12/21/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/21/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location GA

0.00

160

Packaging

Memo

0.00

Packaging

GA

5x16/02/08

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

DAS
21
9-89

SEP 07 2016

DAS
21
9-89

SEP 07 2016

Picklist Print

Monday, December 21, 2015 11:53:59 AM

Page 1

Work Order ID: 140325

140325

Parent Item: D5274-3

D5274-3

Parent Item Name: Step Extrusion

Start Date: 12/21/2015

Required Date: 12/21/2015

Start Qty: 12.00

Required Qty: 12.00

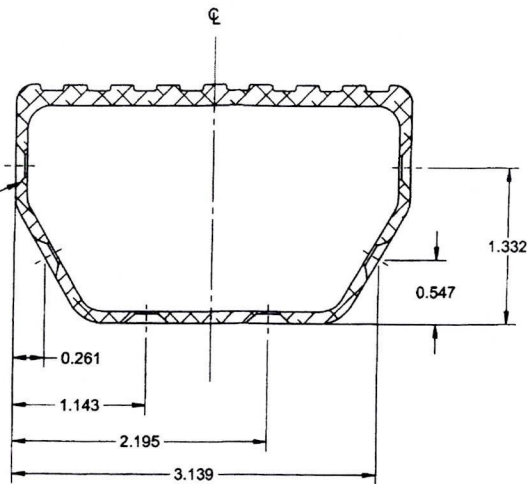
Comments: IPP REV:A 15.07.09 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120		Manufactured	No				Each	0.0000		6.31579			DAS
D2622-120													24
Step Extrusion													9-89

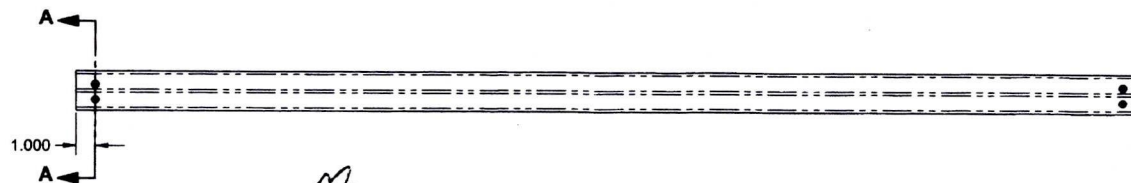
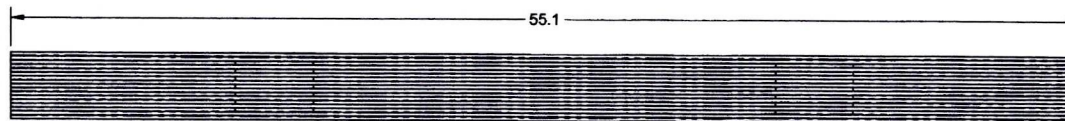
JAN 20 2016

11134783 → 6

CSK $\phi 0.201$
 $\phi 0.385 \times 100^*$
 6 PL



SECTION A-A



D5274-1 STEP EXTRUSION

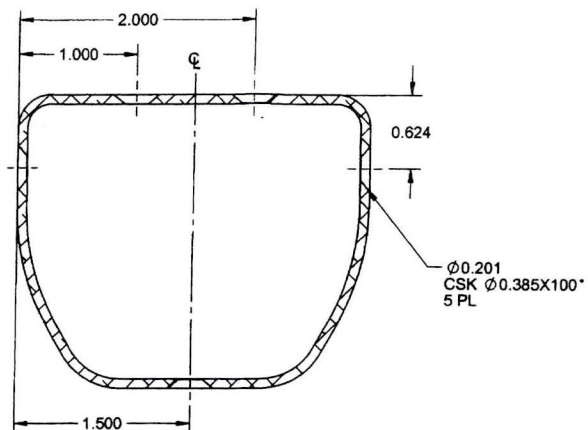
NOTES:

- 1) MATERIAL: MADE FROM D2244-55.1
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER MACHINING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5274-1" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: 6.04 lbs

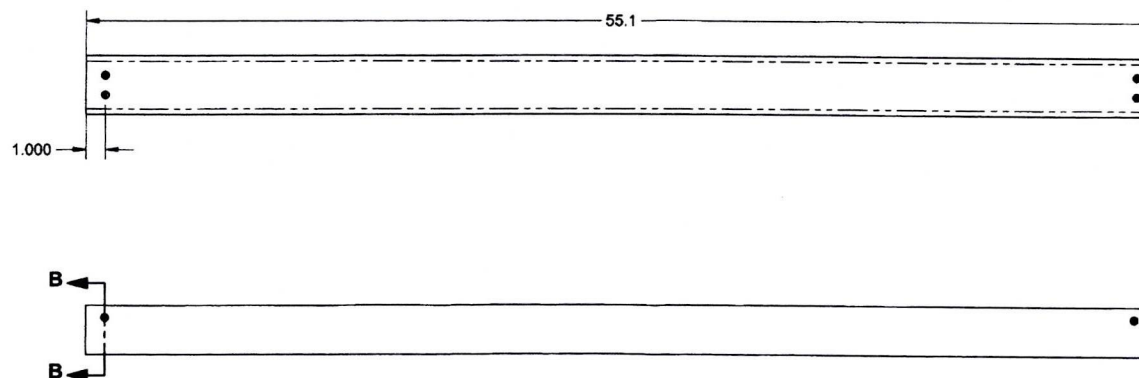
RELEASED
 2015-12-07
 EN 15-149

APPROVED

A NEW ISSUE		CC	15.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CC	DART AEROSPACE USA, INC EUGENE, OREGON, USA	
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CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5274	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STEP EXTRUSION	NTS
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SECTION B-B



D5274-3 STEP EXTRUSION

NOTES:

- 1) MATERIAL: MADE FROM D2622-55.1
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER MACHINING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5274-3" PER DART QSI 044, SECTION 6.1
- 7) WEIGHT: 4.08 lbs

RELEASE
2015-12-07

APPROVED

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CHECKED	VS	DRAWING NO.	REV. A
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Topic 5x
Sadb-038



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911362

Date: 08-Mar-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
5 ea	Part: 140325 D5274-3 STEP Job: 19105	Rev: A PO: 31098	Line: 10
DATE: 8/3/16			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: 			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.			
MADE IN CANADA.			